

Work Order ID 66128

Monday, February 07, 2011 10:53:38 AM



Page 1

Item ID: D2438

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 2/8/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: MUF Date: 11-02-07 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2438	Rev C

100		0.00
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PURCHASING

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D2438

prog rev: Cdwg rev: C

364.063

B11-2-9



110	QC2- Inspect parts off machine FAI/FAIB	0.00
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QC

Memo

0.00

Quality Control

Ensure Material Release Note is attached

B11-2-9

120	QC8- Inspect parts - second check	0.00
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QC

Memo

0.00

Quality Control

(6.786" center to center)

11 02 10 56

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Item Name: Clamp

Start Date: 2/8/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

ca 11/02/11
MF
11-02-15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, February 07, 2011 10:53:34 AM

Page 1

Work Order ID: 66128



Parent Item: D2438



Parent Item Name: Clamp



Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: E 05.06.28 Bending removed KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	222.2800	0.04	1.684211	2.3		
304/316 Sheet .063											2.3		

Location

Loc Qty

Loc Code

MAT

222.28

111323

0

116623

222.28

116623

55

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

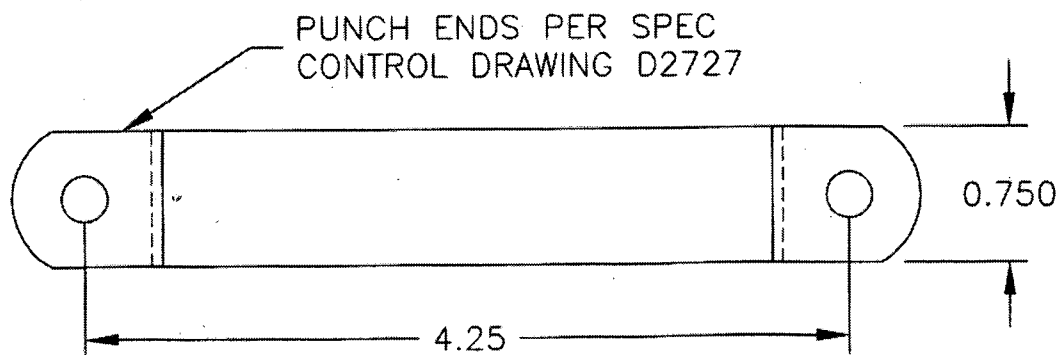
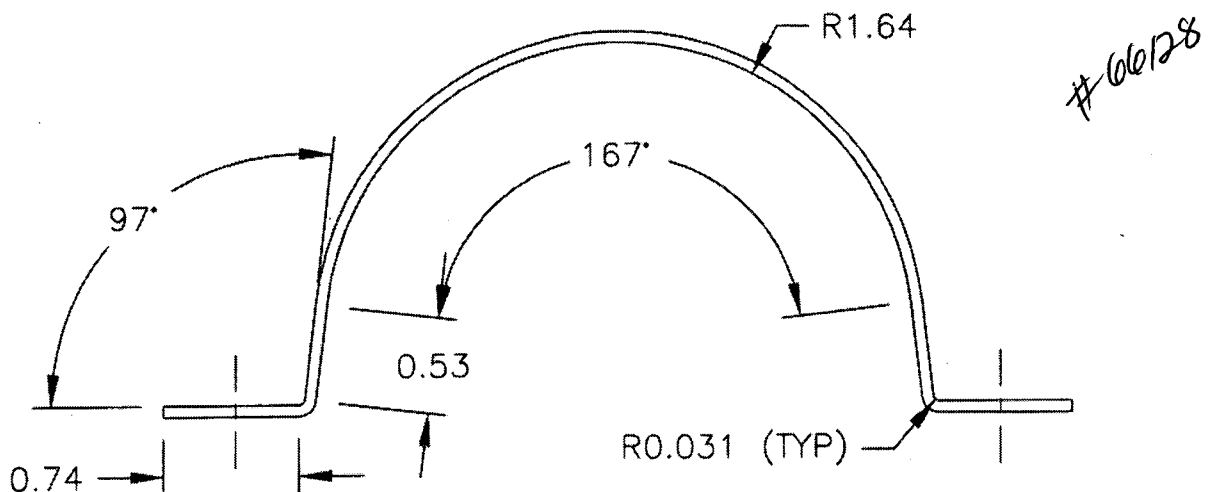
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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MD</i>	APPROVED <i>KE</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
49.06.17 KE



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

00.06.06
CP 00.06.07

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